



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

005075

D350-567-143
Job Sheet 181844



Part No: D350-567-143

Job Qty: 1 ea

Part Name: Floor Window Close Out (Energy Attenuating Seats)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/9/18

Job Tracking No:

Due Date: 9/5/18

Created By: Marie Lajeunesse,

Type: SOLD

Description:

Note: DWG REV F IPP REV:A 13.04.01 AS PER DSI9590 REV.E DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		9/5/18	0.00	0.00	Start Up Stores/Pkg-2		AUG 21 2018
110	Packaging	1 pcs		9/5/18	0.00	0.00	Packaging1-3		AUG 21 2018
120	QC	1 pcs		9/5/18	0.00	0.00	QC4		AUG 21 2018
130	Packaging	1 pcs		9/5/18	0.00	0.00	Packaging3-1		AUG 21 2018
135	DC	1 pcs		9/5/18	0.00	0.00	DC		AUG 21 2018
140	QC21-FG	1 Ea		9/5/18	0.00	0.00	QC21		AUG 21 2018

Part Op 130 - Identify and pack for shipping as per PPP D350-567-143 Location: _____

Descriptions: 135 - Photocopy bluefile & type labels per PPP D350-567-143 CHG001

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-3A	Bolt	5 Ea (5 ea)	90-Start up Operation	5056462
AN525-10R6	Screw	2 Ea (2 ea)	90-Start up Operation	FH137307
AN525-832R7	Screw	2 Ea (2 ea)	90-Start up Operation	5067896
D3802-1 -024"	Window Seal (\$ Per Foot)	1 2 Ea (2 ea)	90-Start up Operation	5069414
D4434-041	Fwd Bracket Assembly	1 Ea (1 ea)	90-Start up Operation	5074337
D4434-047	Cover Assembly	1 Ea (1 ea)	90-Start up Operation	5068704
D4435-9	Bracket	2 Ea (2 ea)	90-Start up Operation	5076969
D4436-041	Aft Bracket Assembly	1 Ea (1 ea)	90-Start up Operation	5082986
D4441-1 -024"	Rubber Seal	1 2 Ea (2 ea)	90-Start up Operation	5069414
D4971-041	T/R Bellcrank Cover Assembly	1 Ea (1 ea)	90-Start up Operation	5084057
MS21042L06	Nut	7 Ea (7 ea)	90-Start up Operation	5048834
MS21042L08	Nut	2 Ea (2 ea)	90-Start up Operation	5044234
MS21042L3	Nut	5 Ea (5 ea)	90-Start up Operation	5089340
MS21059L3	Nut Plate	2 Ea (2 ea)	90-Start up Operation	5071352
MS35206-229	Screw	7 Ea (7 ea)	90-Start up Operation	5067268
NAS1149F0332P	Washer	10 Ea (10 ea)	90-Start up Operation	5103666
NAS1149FN616P	Washer	14 Ea (14 ea)	90-Start up Operation	5064085
NAS1149FN816P	Washer	2 Ea (2 ea)	90-Start up Operation	F117316-25

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-3A	5	488	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Cross tube ☐ Small Fab ☐ Water Jet ☐ Prod Eng Coord. ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____ Step _____		 Container No: S103968 Part: D350-567-143 Job No: 181844 Serial No/Batch: S103968 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: TC STC SH92-18 Issue Date FA2516 SH989NE 09/06/30, FAA STC S103968				MRB (QSI042) Approval	
Description Work Order						Completed By	
						Lead hand / Supervisor Approval Verification	
						QC / QA Coordinator Approval	
Root Cause							
Environment ☐	No Re-verification ☐	P					Positioned Wrong ☐
Design ☐	Operator ☐	B					Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	C					Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐		Cracks ☐	BOM/Route ☐	Grain ☐		Part Incorrect ☐
Handling/Pre ☐	Training ☐		Crimp/Kink/Ripple/Wave ☐	Broken/Damage/Defect ☐	Wrong Stock Pulled ☐		Part Lost/Missing ☐
Material ☐	Use for Testing ☐		Cuffs ☐	Inspection Incomplete/Unqualified ☐	Out of Sequence ☐		Part Moved ☐
Internal Transport ☐	Poor Information ☐		Crushing ☐	Contamination ☐	Off-set ☐		Drawing ☐
Tribal Knowledge ☐	Rushing ☐		Heat Treat ☐	Countersink ☐	Mislabeled ☐		Finish ☐
LOA ☐	Product Improvement ☐		Wave/Twist in Tube ☐	Cut Too Short ☐	Fit/Function ☐		Misread ☐
Substation ☐	Process Improvement ☐		Marks/Chatter ☐	Instructions Incomplete/Unclear ☐	Misaligned/off center ☐		Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐			Drill Holes ☐			
Misidentified ☐	Past Due ☐		OTHER : _____				

AN525-10R6	2	172	0
AN525-832R7	2	119	0
D3802-1	2	40	0
D4434-041	1	6	0
D4434-047	1	11	0
D4435-9	2	6	0
D4436-041	1	8	0
D4441-1	2	566	0
D4971-041	1	3	0
MS21042L06	7	158	0
MS21042L08	2	3,164	0
MS21042L3	5	4,364	0
MS21059L3	2	318	0
MS35206-229	7	123	0
NAS1149F0332P	10	1,067	0
NAS1149FN616P	14	257	0
NAS1149FN816P	2	196	0

Part Specifications

Specifications could not be found.

Plex 8/10/18 8:15 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																						
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																						
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																						
Large Fab ☐	Composite ☐	Supplier ☐																							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
										QC / QA Coordinator Approval															
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐																				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐																				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐																				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

PAGE 1 OF 1

Description: FLOOR WINDOW CLOSEOUT (ENERGY ATTENUATING SEATS)

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2.0 Parts List

Qty -141	Qty -143	Qty -145	Part Number	Description
X			D350-567-141	FLOOR WINDOW CLOSE-OUT KIT (REGULAR SEATS)
	X		D350-567-143	FLOOR WINDOW CLOSE-OUT KIT (ENERGY ATTENUATING SEATS)
		X	D350-567-145	FLOOR WINDOW CLOSE-OUT KIT (AS 350 B3e)
1	1	1	D3802-1-024	SEAL (24")
1	1		D4434-041	FWD BRACKET ASSEMBLY
1	1		D4434-047	COVER ASSEMBLY
1			D4435-045	T/R BELLCRANK COVER ASSEMBLY
2	2	2	D4435-9	BRACKET
1	1	1	D4436-041	AFT BRACKET ASSEMBLY
1	1	1	D4441-1-240	RUBBER SEAL (24")
		1	D4730-020-030	VELCRO STRIP
	1	1	D4971-041	T/R BELLCRANK COVER ASSEMBLY
		1	D5076-041	FWD BRACKET ASSEMBLY
7	5	5	AN3-3A	BOLT
2	2	2	AN525-10R6	SCREW
2	2	2	AN525-832R7	SCREW
		1	CB 200	3.5g ACRYLIC ADHESIVE
7	7	7	MS21042L06	NUT (OR MS21042-06)
2	2	2	MS21042L08	NUT (OR MS21042-08)
5	5	5	MS21042L3	NUT (OR MS21042-3)
2	2	2	MS21059L3	NUTPLATE
7	7	7	MS35206-229	SCREW
12	10	10	NAS1149F0332P	WASHER (AN960-10L)
14	14	14	NAS1149FN616P	WASHER (OR AN960-6L)
2	2	2	NAS1149FN816P	WASHER (OR AN960-8L)

3.0 Weight and Balance

The following is the net weight increase associated with the D350-567-141/-143/-145 Kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-567-141/-143/-145	3.9 lb	17.9 in	69.8 in-lb	65.5 in	255.5 in-lb
Floor Window Close-out Kit	1.77 kg	0.45 m	0.80 m-kg	1.66 m	2.94 m-kg

4.0 Installation Procedure

Notes:

- Figure 2 shows the general arrangement and installation of the D350-567-141/-143/-145 Close-out Kits. The procedure that follows outlines the step-by-step procedures for installing the kit with reference photos from the initial installation.
- In conjunction with this modification, it is acceptable to remove the interior floor windows as applicable. Note that the structural reinforcement around the window opening is still required.
 - D350-567-115 - OK to remove D3295-041
 - D350-567-031 - OK to remove D3212-1
 - D350-567-011 - OK to remove D2214
 - D350-567-021 - OK to remove D2951
- It is acceptable to drill/trim the D350-567-141/-143/-145 Close-out Kits as required to improve fit.

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY:

D. SHEPHERD (DE # 02)

DATE: 15.01.12
CERT. NO.: SH92-18
ISSUE NO.: 6

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. F
MFG. APPR.	N/A	DSI 9590	SHEET 2 OF 19
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	FLOOR WINDOW CLOSE-OUT KIT	NTS
DATE	15.01.12	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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REFERENCE ONLY

REFERENCE ON A